

**Work Order ID 64413**

Monday, December 06, 2010 8:16:55 AM



Page 1

Item ID: D3646-1

Accept



Setup

Start



Revision ID:

Item Name: Arm

Stop



Start Date: 12/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/12/10 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	0.00	B	Dwg as chg'd DT8958 might not be right.	10X	10X	10X
D3646	Rev A B	NC BRAKE							
100			0.00						
Brake NC									
Brake NC		1-Punch to length as per Dwg D3646 & template DT8958							
110			0.00						
Small Fab	Small Fab								
Small Fab		Memo	0.00						
Small Fab		1-Deburr							
120	QC5- Inspect part completeness to step on W/O		0.00						
QC		Memo	0.00						
Quality Control									

SB 10/12/10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 112 588

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40  
300  
9:10.

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

2 M 10/12/10

10 BR 10-12-10.

10 q

150



Packaging

Packaging

Identify as per dwg & Stock Location: 229

0.00

Memo

0.00

10/12/10 100

W/O:		WORK ORDER CHANGES					
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Start



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Item Name: Arm

Stop



Start Date: 12/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

10/12/15  
 JMC  
 10-12-15

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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"								

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# Picklist Print

Monday, December 06, 2010 8:17:00 AM

Page 1

Work Order ID: 64413



Parent Item: D3646-1



Parent Item Name: Arm

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			100	f	116.2609	1.98	20.84211		m-f 6/10/09	

Location	Loc Qty	Loc Code
MAT	116.2608934	
114482	0.002677	
115180	0.93405	
115593	10.99364	
115990 ✓	104.330526	
MAT014	0.00002	
114356	0.00002	

20-84211

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SHOP COPY

RETURN TO

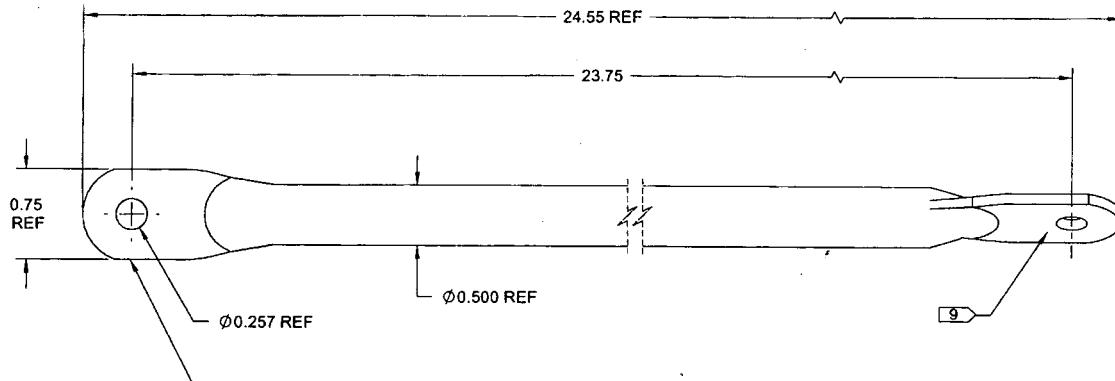
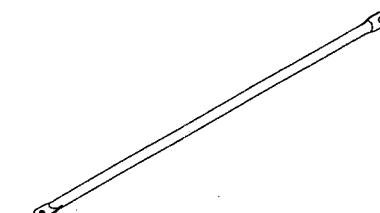
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. C4413  
BS-012-6



D3646-1 ARM

RELEASED  
09/03/2004

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

B	REFORMAT DWG. ANGLE 66° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3646	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM	NTS
DATE	09.06.04	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ISSUED OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

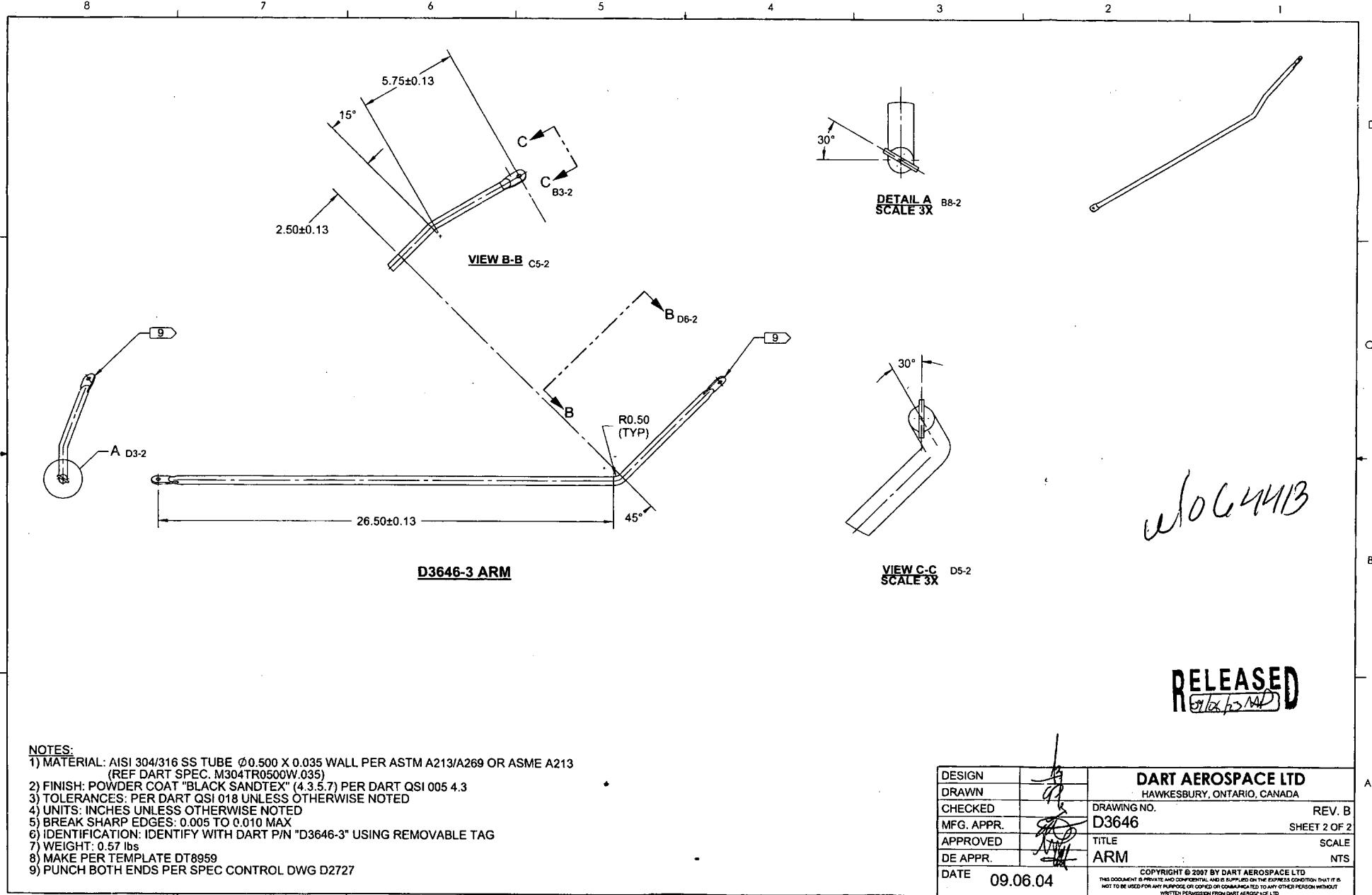
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